

Work Order ID 45692

July 6, 2009 7:28:10 AM



Page 1

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 7/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

AA 090706

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 509102/13

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

W/O 45458

130

*SHIPPED TODAY
09/07/14
AA*

Work Order ID 45692

July 6, 2009 7:28:10 AM



Page 2

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 7/07/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 8.07.14

Picklist Print

July 6, 2009 7:28:10 AM

Page 1

Work Order ID: 45692

Parent Item: D3186-3RevD

Parent Item Name: Spacepod Door, LH



Comments:

Start Date: 7/07/09

Required Date: 7/15/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-1MRevD		Manufactured	No				Each	0.0000	1.0000			
												
SPACEPOD DOOR LH												

Date: Tuesday, 10/02/2009 3:06:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR LH
Job Number : 45692	
Estimate Number : 12635	
P.O. Number :	Part Number : D31863
This Issue : 10/02/2009 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 45691	Material :
Written By :	Due Date : 10/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	45692A	SPACEPOD DOOR LH
-----	--------	------------------

**Comment:** Sub-Component SPACEPOD DOOR LH

1 x D3186-1M Batch

245692AAO090713

2.0 ✓	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

AO090713

3.0 ✓	QC5	INSPECT WORK TO CURRENT STEP
-------	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP502/02/13

4.0 ✓	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0 ✓	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion ✓



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090706	100	Dwg 3186-3 Detail D 9804yp is now corrected to L2000 1.130	<i>[Signature]</i>	090713		<i>[Signature]</i> 4.07.13 451 042	S 01/07/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

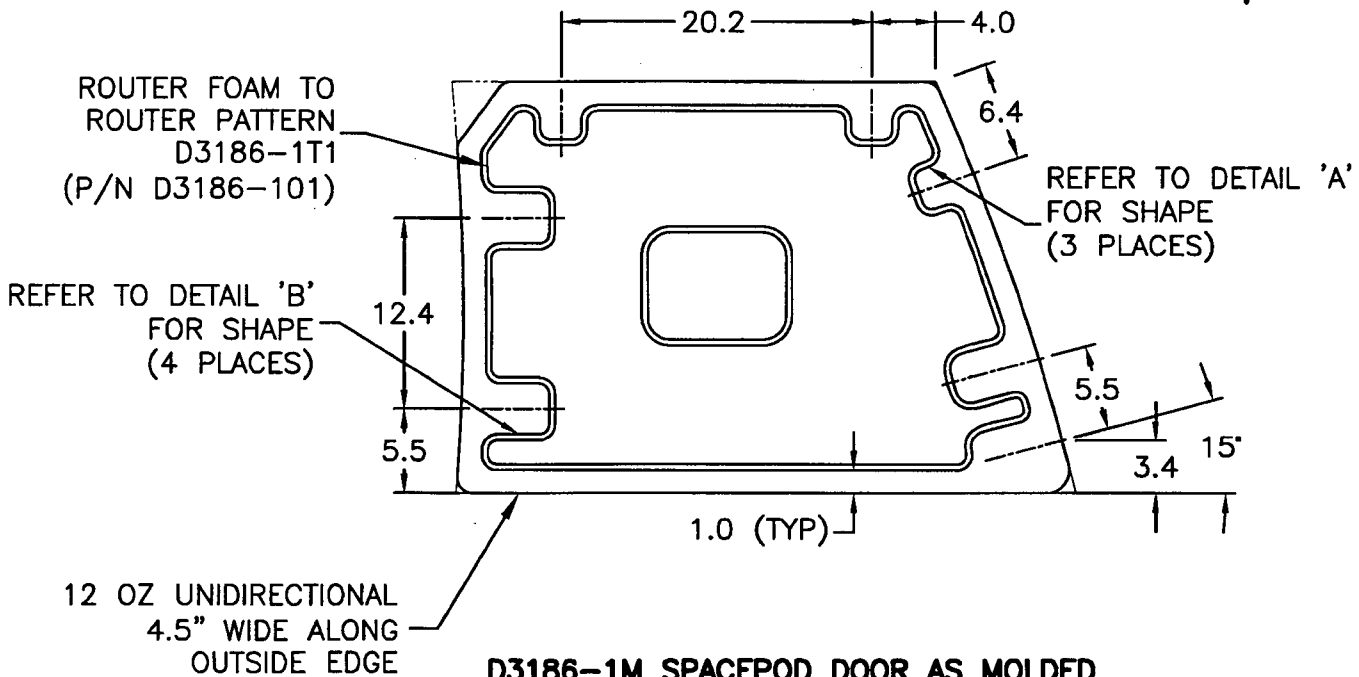
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 45612

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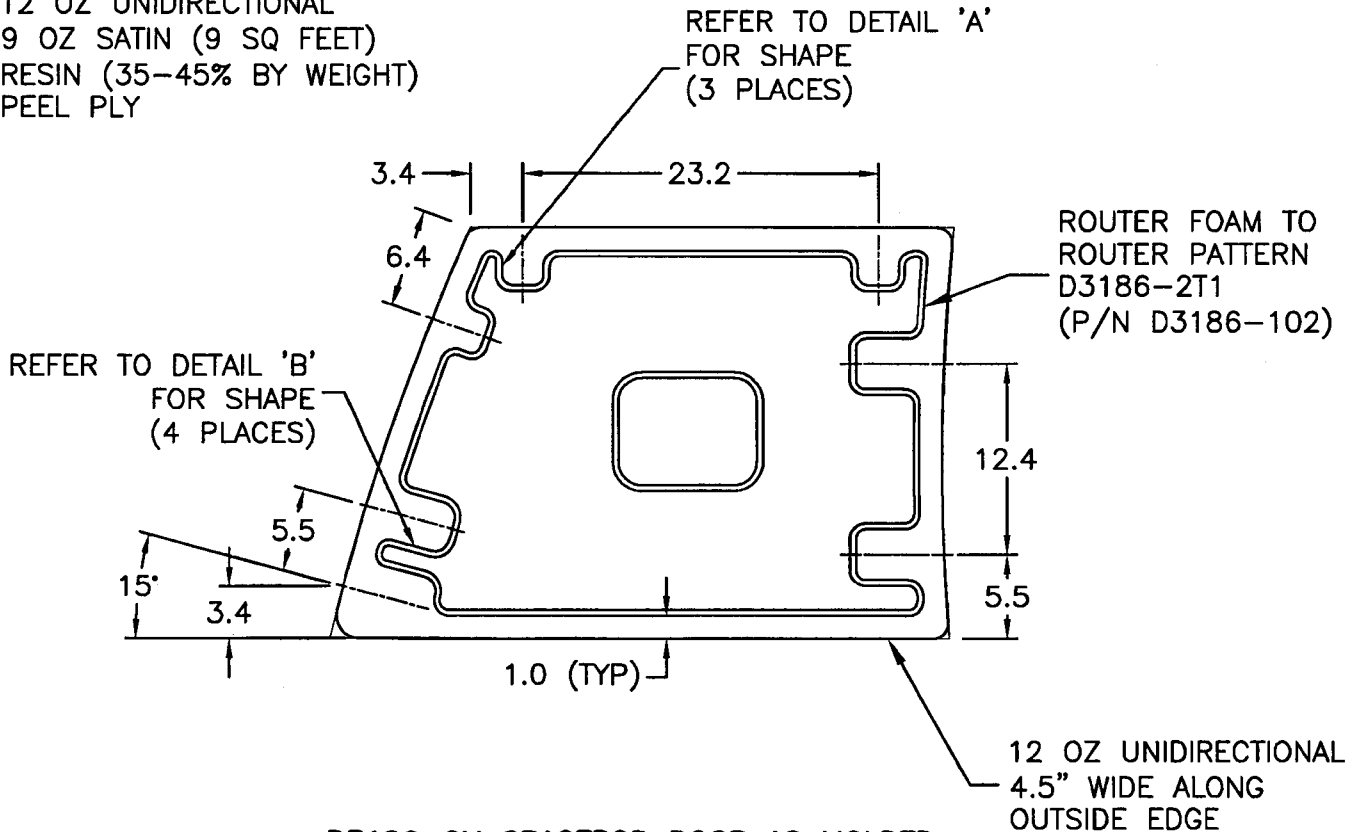
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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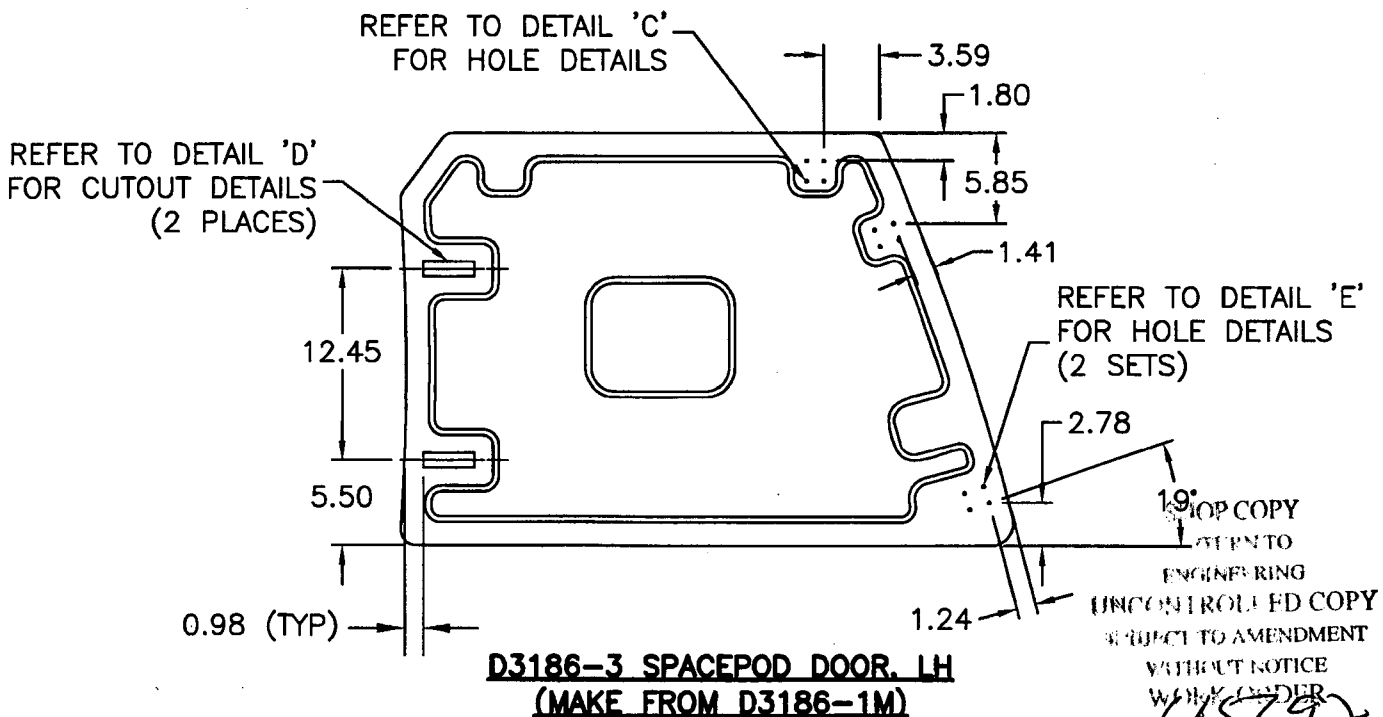
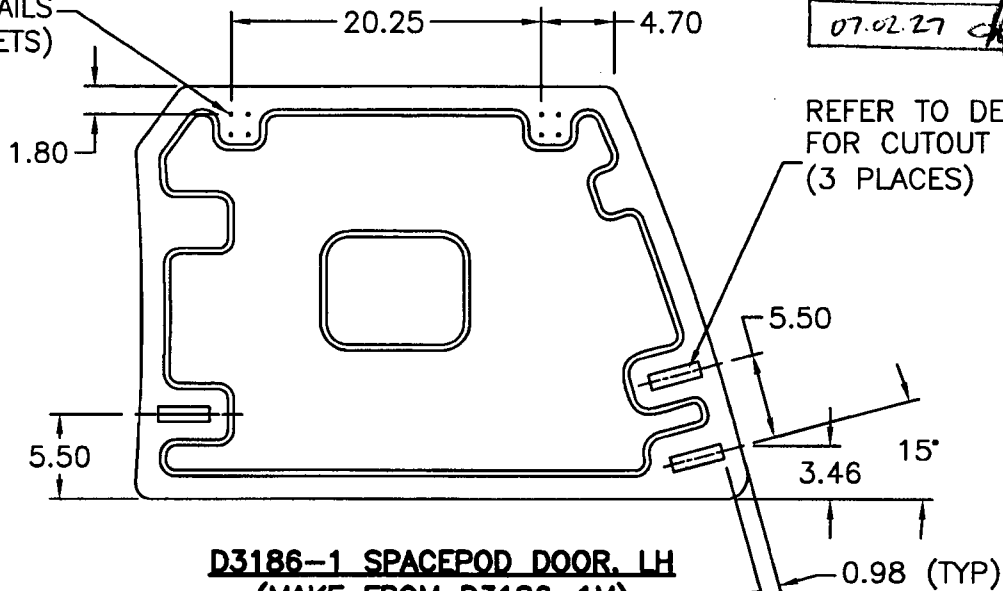
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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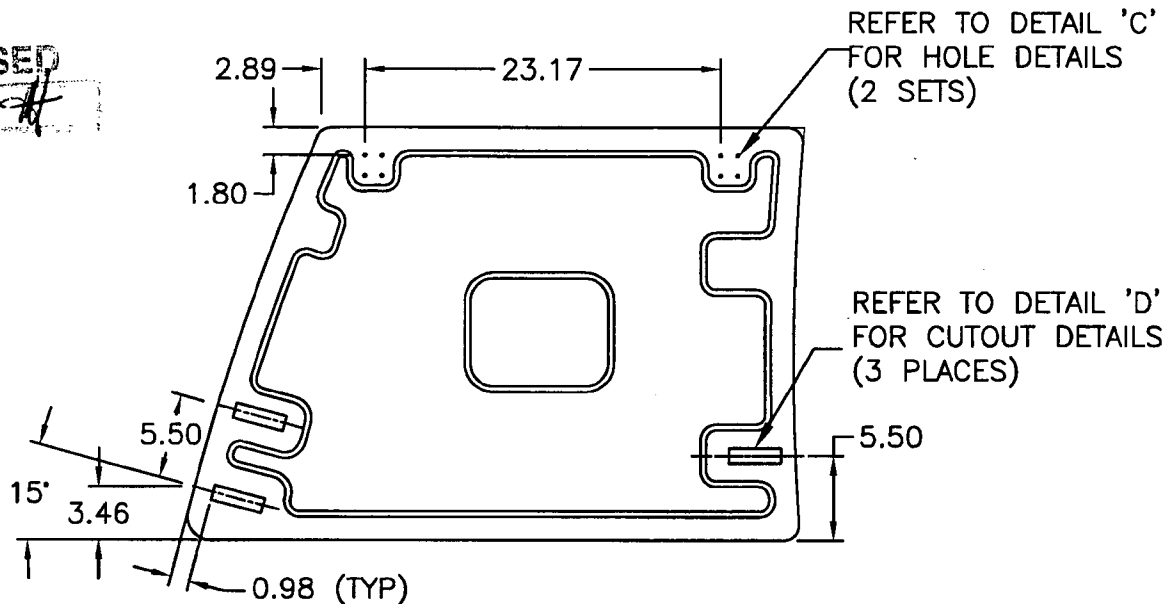
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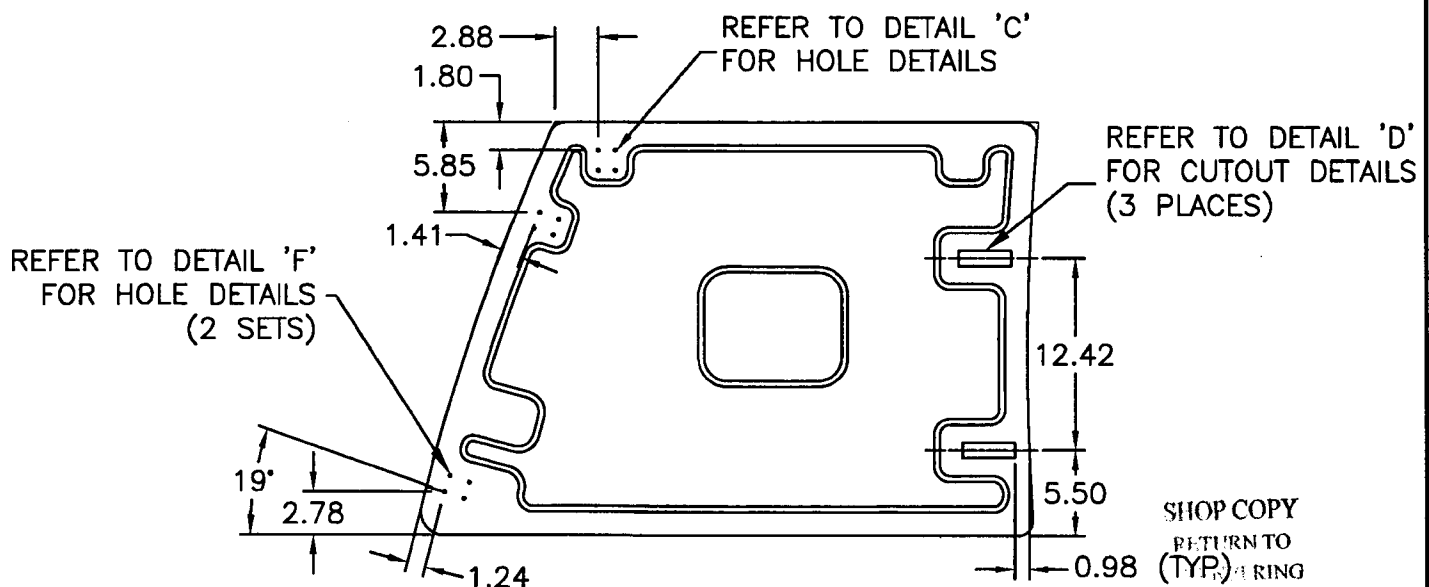
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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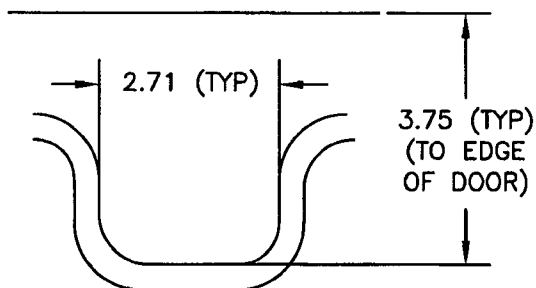
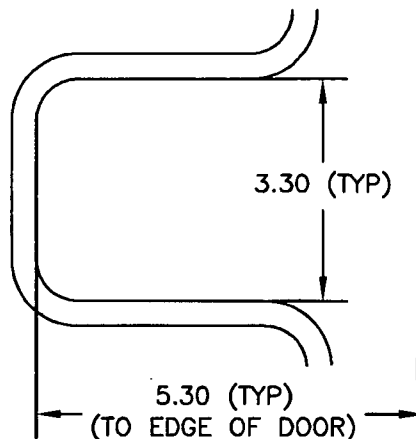
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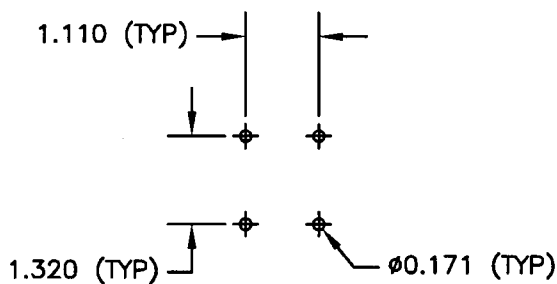
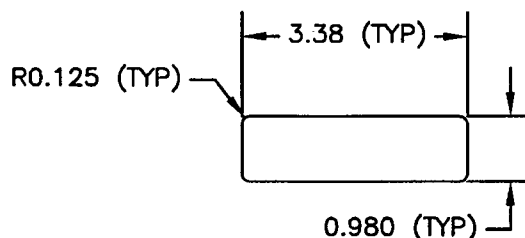
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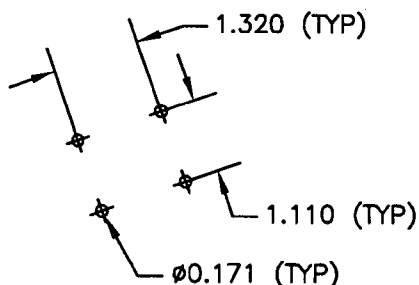
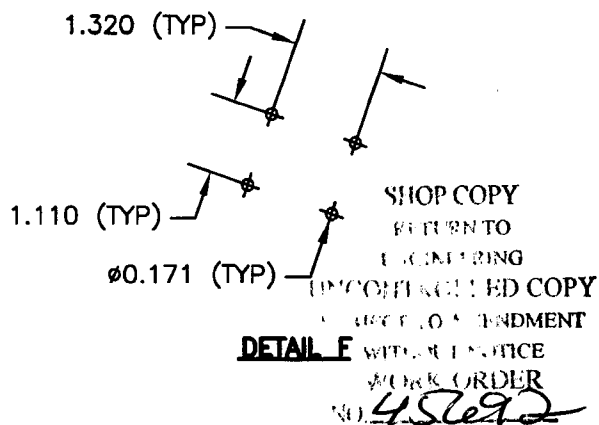
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

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